

Work Order ID 120094

120094

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Wednesday, June 04, 2014 2:55:41 PM

Item ID: D4636-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Receptacle Bracket Assembly

Start Date: 6/09/14 Start Qty: 64.00

64

Cust Item ID:

Required Date: 6/09/14 Req'd Qty: 64.00

64

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: MLJ

Date: 14-06-05

Tooling:

Date:

Stop

NR2

QC: _____

Date:

SPC (Y/N): _____

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4636	D								
100	FLOW WATER JET	0.00				72	0		DAS 23 9-89 14-06-22
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4636-3 as per Dwg Dwg Rev: <u>0</u> Prog Rev: <u>0</u> 2-Deburr if necessary								
304 2099									
110	QC2- Inspect parts off machine FAI/FAIB	0.00				72	0		DAS 23 9-89 14-06-22
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

213
14/6/23

(72)
cent

Work Order ID 120094

Wednesday, June 04, 2014 2:55:41 PM

120094

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Item ID: D4636-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Receptacle Bracket Assembly

Stop *NS2*

Start Date: 6/09/14 Start Qty: 64.00

64

Cust Item ID:

Required Date: 6/09/14 Req'd Qty: 64.00

64

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5 1407-04

4-73

Picklist Print

Page 1

Wednesday, June 04, 2014 2:55:40 PM

Work Order ID: 120094

120094

Parent Item: D4636-043

D4636-043

Parent Item Name: Receptacle Bracket Assembly

Start Date: 6/09/14

Required Date: 6/09/14

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC IPP REV:B
 13.06.20 DWG PC2 DD VERF:JLM IPP REV:C 13.07.17
 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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2350-18-C3Y

Purchased

No

Each

519.0000

64

**

DAS

36

9-89

2350-18-C3Y

Rigid Receptacle

LocationLoc QtyLoc Code

ST395

519

M127987

6

M128047

513

M304S20GA

Purchased

No

sf

279.1519

**

DAS

23

9-89

M304S20GA

304/316 .040 Sheet

LocationLoc QtyLoc Code

MAT020

279.1518948

m126852

0.31

m127454

26.1018948

m128435

126.74

m129128

126

68-6

9C

DAS

MS20426AD3-2

Purchased

No

Each

18,153.00

**

DAS

36

9-89

MS20426AD3-2

Rivet

LocationLoc QtyLoc Code

Mezz

18153

1173

8873

13276

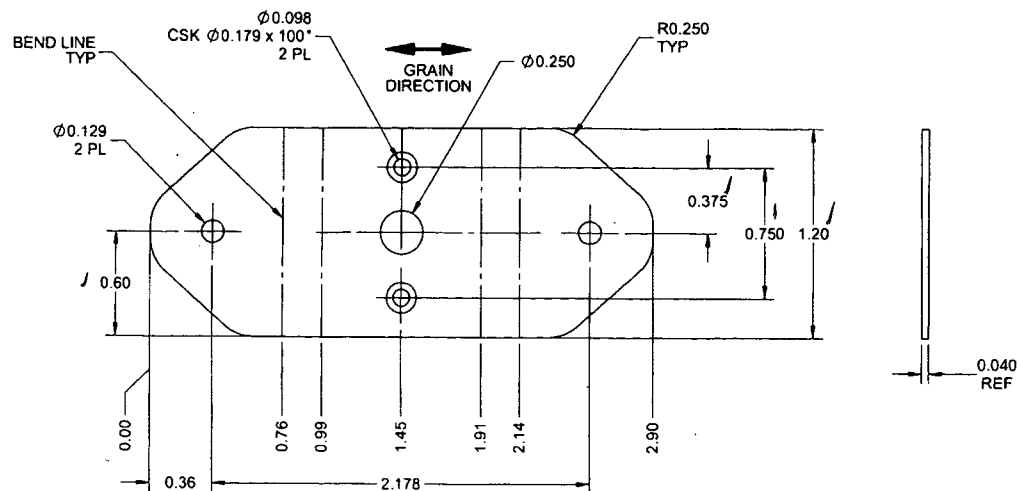
9280

1128754
 500

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	23 9-89	Audited by:	<i>EB</i> 21 9-89	Preliminary Approval:	
Date:	<i>14-06-22</i>	Date:	<i>14/6/23</i>	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revE



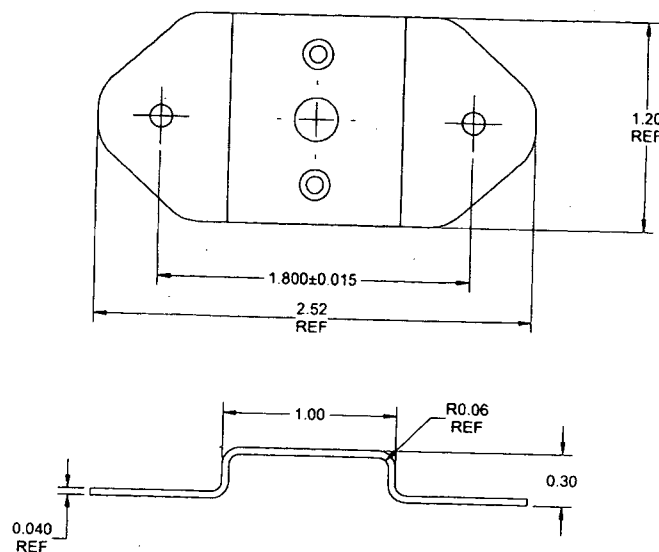
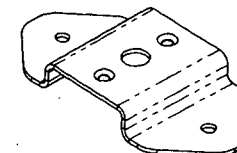
D4636-3F FLAT PATTERN RECEPTACLE BRACKET

NOTES:

- 1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S20GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASED
2013-12-23
AS

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. D
MFG. APPR.	AS	D4636	SHEET 3 OF 7
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BRACKET ASSEMBLY	NTS
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D4636-3 RECEPTACLE BRACKET

RELEASED
2013-12-23
ADS

NOTES:

- 1) MATERIAL: MAKE FROM D4636-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4636	REV. D
MFG. APPR.	N		SHEET 2 OF 7
APPROVED	[Signature]	TITLE	SCALE
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